| Work Orde Tuesday, March | | | | | *980 | 128* | | | | | | | Page 1 | |
|---|---------------------------------------|---|---|--|----------------------|-------------------|------------|--------------|---------------|--------------|---------------|------------------|----------------|-----|
| Revision ID: (tem Name: | D2221 350 Basket Ba 3/4/2013 4/9/2013 | Start Qty: 1.00 Req'd Qty: 1.00 | • | :1* :1* | Accept | *N900 Cust Item I | | 100 |)* · | Setup S | Start Stop | *N: | S1* S2* | |
| Approvals: | Process Pla | nn: | Date: | 13-5 | Tooling: SPC (Y/N): | | ate: | | I | | Start Stop | *N *N | R1* R2* | |
| Sequence ID/ Work Center II |) | Operation Description | | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Rejec Qty | | leject lumber | Insp. Stamp | |
| Draw Nbr | Rev | ision Nbr | | | | | | | | | | | | |
| D2221 | Rev | Н | | | | | | | | | | | | |
| *100 *100* Large Fab Large Fab | | 2- remove b dwg D2221 3- tack wele A/R ER ***PLEAS IF MAKING | basket from jig a l d mesh on baske 316 S.S. Rod E E NOTE SEE D G -141/-041A C | nd weld D34 t as per dwg tatch: / 24 WG*** UT BUSHIN | | NDS, OR -143/- | 7 (13:3 | 3.12 | 1/2 | | | | | · · |
| *110 *11 0 * | | QC9- Inspect visual per | QSI004- Fusion | Welds | 0.00 | | | | | 13- | හු- | 13 | 09 | |

Quality Control

| | | | | | | | | | | DQA: | Date: | |
|---------------|-------------|----------------------|--|-------------------|----------------------------|----------|---------|--------------------|------------|--------------|---------------|---|
| NCR: Y | 'es / I | No | | | WORK ORDER NON-C | O | NFOR | MANCE / UPD | ATE | | | |
| · | | | | | | | | | | QA Closed: | Date: | |
| Manla Onda | | | | | DISPOSITION | | | | AGAINST DE | PARTMENT, | /PROCESS | |
| Work Orde | er: —— | | ······································ | | Rework | 1 | | Skid-tube | Crosstube | 1 | Water Jet | Engineering |
| Part N | lo. | | | | Scrap | | | Machining | Small Fab | Pro | d. Eng. Coor. | Quality |
| 1 4761 | ··· | | | | Use-as-is | 1 | | noforming | Finishing | 4 | re/Packaging | Other |
| NCR N | No. | | | | Work Order Update | 1 1 | | Large Fab | Composite | | Supplier | 1 1 |
| | | | | | | , | | | | | | |
| Root | | | | Descri | ption of work order update | 1 | Initial | Acti | | Sign & | | |
| Cause | Da | te Step | Qty | | or Non-conformance | Ch | ief Eng | Descri | ption | Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | | | |
| Equip/Tooling | | | | | • | | | | | | | |
| Operator | | | 1 | | | | | | | | | |
| Material | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | |
| Other | | | | | | | | | | | | |
| Process | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | : | |
| Training | | | | | | | | | | | | |
| Unapproved | | | | | | <u> </u> | T CATE | CORY | | | | <u> </u> |
| l and: | ng Gear | | | | General | AU | LICATE | GORT | | | | , |
| Lanui | Bend | ling | | | Bend | Г | Grain | | | Ovalized | | Pressure/Forced |
| <u>'</u> | \vdash | ıırıg re Not Conc | ontric to | | BOM/Route | - | Hardwa | ere | <u> </u> | Over/Under | r tolerance | Temperature/Cure |
| | Crac | | entric to | ^{0/3} - | Broken/Damaged | \vdash | 4 | ion Incomplete | | Part Incorre | | Weld |
| | ⊢ | ks hed/Crimpe | Ч | - | Burrs | - | 4 ` | tions Incomplete/U | Inclear - | Part Lost/M | <u> </u> | Wrong Stock Pulled |
| | Cuffs | • | u, | | Contamination | \vdash | Mainte | • | | Part Moved | | |
| ! | | Treat | | - | Countersink | | Mislabe | | | Positioned | | |

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

| Work Ord Tuesday, March | | | | *980 | 128* | | | | | | Page 2 | |
|--|-------------------------|---|--------------|------------------------------|--------------------------|------------|--------------|------------|--|------------------|--------------------------|--|
| Item ID: Revision ID: Item Name: | D2221 350 Basket F | Base | | Accept | *N900 | 040 | 100 |)* | Setup Star | 1.71 | S1* S2* | |
| Start Date: Required Date Reference: | 3/4/2013 :: 4/9/2013 | Start Qty: 1.00 Req'd Qty: 1.00 | *1* *1* | | Cust Item I Customer: | D: | | | | | | |
| Approvals: | Process P | lan: | Date: | Tooling: SPC (Y/N): | | ate: | | | Run Star Stop | 171 | R1* R2* | |
| Sequence ID/ Work Center I 120 *120* QC Quality Control | ID | Operation Description QC6- Inspect dimension Memo | s to drawing | Set Up/ Run Hours 0.00 | Tool ID | Tool # | Plan Code | Accept Qty | t Reject Qty (ろ- <u>〇</u> <u>ろ-</u> \2 | Reject Number | Insp. Stamp (DA) (09 89 | |

0.00

0.00

125

125
HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

| | | | | | | | | | | | DQA | i: | Date: | |
|---------------|----------|-----------|-----------|----------|--------------|----------------------------|----------|---------|--------------------|------------|------------|--------------|-------|--------------------|
| NCR: | Yes | / No | | | | WORK ORDER NON-C | 100 | NFORM | MANCE / UPD | ATE | | | | |
| | | | | | | | | | | | QA Closed | l: | Date: | |
| Work Orde | or: | | | | | DISPOSITION | | | | AGAINST DE | PARTMEN | T/PROCESS | | |
| WORK Of GR | er. - | | | | | Rework | 1 | | Skid-tube | Crosstube |] | Water J | let | Engineering |
| Part I | ۷o. | | | | | Scrap | | | Machining | Small Fab | Pı | od. Eng. Co | - | Quality |
| 1 4111 | ٠٠. | | | | | Use-as-is | 1 | | noforming | Finishing | 4 | ore/Packagi | | Other |
| NCR I | No. | | | | | Work Order Update | 1 | | Large Fab | Composite | | Suppl | ier | |
| | - | | | | | | | | | | | | | |
| Root | | | | | Descri | ption of work order update | 1 | Initial | Acti | | Sign & | | | : |
| Cause | | Date | Step | Qty | | or Non-conformance | Ch | ief Eng | Descr | iption | Date | Verifica | tion | QC Inspector |
| Doc/Data | | | | ! | <u> </u> | | | | | | | | | |
| Equip/Tooling | Ш | | | | | | | | | | | | | 1 |
| Operator | | | | | | | | | | | | 1 | | |
| Material | | | | | | | | | | | | | | : |
| Setup | Ш | | | | | | | | | | | | | |
| Other | Ш | | | | | | | | | | | | | <u> </u> |
| Process | Ш | | | | | | Ì | | | | | | | |
| Supplier | Ш | | | | | | | | | | | | | |
| Training | | | | | | | İ | | | | | | | |
| Unapproved | | | | <u> </u> | <u> </u> | | | | | <u></u> | | | | |
| | | | | | | | AUI | T CATE | GORY | | | | | |
| Landi | | | | | _ | General | | ٦ | | | . | | _ | . |
| | \vdash | Bending | | | <u> </u> | Bend | | Grain | | <u> </u> | Ovalized | | | Pressure/Forced |
| | Щ | Centre No | ot Concer | ntric to | o/s | BOM/Route | \vdash | Hardwa | | <u> </u> | ⊣ | er tolerance | _ | Temperature/Cure |
| | Ш | Cracks | | | | Broken/Damaged | | -1 ` | ion Incomplete | <u> </u> | Part Incor | | - | Weld |
| | Ш | Crushed/ | Crimped. | | | Burrs | _ | - | tions Incomplete/U | Jnclear | Part Lost/ | _ | | Wrong Stock Pulled |
| | Ш | Cuffs | | | L | Contamination | \perp | Mainte | enance | _ | Part Move | | | |
| | 1 | Heat Trea | at | | | Countersink | | Mislabe | eled | | Positione | d Wrong | | |

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

| Work Orde Tuesday, March | | | | *980 | 128* | | | | | | | Page |
|---------------------------------------|----------|---|--|---|--------------------------|--------|--------------|--------------|---------|-------|------------------|----------------|
| Item ID: | D2221 | | | Accept | *N900 | 040 | 100 |)* | Setup S | Start | *N! | S1* |
| Revision ID: Item Name: | 350 Bask | vet Rase | | | | | | | 5 | Stop | *N1(| S2* |
| Start Date: Required Date: Reference: | 3/4/2013 | 3 Start Qty: 1.00 | *1* *1* | | Cust Item I Customer: | D: | | | | | IVI | 7 / |
| Approvals: | Proces | s Plan: | Date: | Tooling: | D | ate: | | | Run S | Start | *NI | R1* |
| •• | | | Date: | _ | | ate: | | | \$ | Stop | *NI | R2* |
| Sequence ID/ Work Center II | D | Operation Description White Gloss (Ref;478) 5-2 | per 081005 4.3-Steel | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accep Qty | Qty | ľ | Reject Number | Insp. Stamp |
| *130* Powdercoat | | Memo | , 3. | 0.00 | | | | | 4 | BL. | 13-3- | · 14. |
| Powder Coating | | FINISH TII ******** 2ND COA [*] START TII | ME M | 200 ecessary*********************************** | **** | | | | | | | |

140

QC3- Inspect Part Finish

Memo

Quality Control

140

| | | | | | | | | | | | | DQA: | Da | te: | |
|----------------------|----------|-----------|------------|----------|-----|----------------------------|-----|--------------|-------------------|------------|----|--------------|---------------|----------|--------------------|
| NCR: | ⁄es | / No | | | | WORK ORDER NON-C | O | NFORM | MANCE / UPD | ATE | | | | | |
| | | | | | | | | | | | - | QA Closed: | Da | te: | |
| Work Orde | or. | | | | | DISPOSITION | | | | AGAINST DI | ΕP | ARTMENT/ | PROCESS | | |
| VVOIR OIG | ٠'٠. | | | | | Rework | | | Skid-tube | Crosstube | ٦ | | Water Jet | | Engineering |
| Part f | No. | | | | | Scrap | | | Machining | Small Fab | 1 | Prod | d. Eng. Coor. | | Quality |
| | • | | | | | Use-as-is | | | noforming | Finishing | ٦ | | e/Packaging | | Other |
| NCR I | No. | | | | | Work Order Update | | | Large Fab | Composite | | | Supplier | | |
| | | | 1 | | D | | | la iki a i | 0 -4: | | Т | C: 0 | | | |
| Root | | Data | Chair | 04 | · | ption of work order update | l | Initial | Actio | | | Sign & | Verificatio | <u>-</u> | QC Inspector |
| Cause | - | Date | Step | Qty | (| or Non-conformance | Cn | nief Eng | Descri | ption | + | Date | vermeatio | | QC Hispector |
| Doc/Data | | | | | | | | | | | ĺ | | | | |
| Equip/Tooling | - | | | | | | | | | | ١ | | | | |
| Operator Material | \vdash | | | | | • | | | | | ļ | | | | |
| Setup | | | | | | | | | | | | | | | |
| Other | | | | | - | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | • | | |
| Unapproved | | | | | | | | | | | | | | | |
| | | | | | | FA | AUL | LT CATE | GORY | | | | | | |
| Landi | ng (| Sear | | | | General | | 7 | | | _ | ŕ | | | 7 |
| | | Bending | | | _ | Bend | _ | Grain | | _ | | Ovalized | | L | Pressure/Forced |
| | | Centre N | ot Concer | ntric to | o/s | BOM/Route | _ | Hardwa | re | | | Over/Under | tolerance | L | Temperature/Cure |
| | | Cracks | | | | Broken/Damaged | | - 4 | ion Incomplete | L | | Part Incorre | ct | | Weld |
| | L | Crushed/ | Crimped. | | _ | Burrs | | - | ions Incomplete/U | nclear | | Part Lost/Mi | ssing | | Wrong Stock Pulled |
| | | Cuffs | | | | Contamination | | Mainte | enance | | | Part Moved | | | |
| | | Heat Trea | at | | | Countersink | | Mislabe | eled | | | Positioned V | Vrong | | - |
| | | Inspectio | n Strip in | Tube | | Cut Too Short | | Misread | t | | | Power Loss/ | Surge | | Other |

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

| Work Orde Tuesday, March | | | | *980 | 128* | | | | | | Page 4 |
|--|----------------------|---|---------------------------|------------------------------------|---------------------------|------------|--------------|--------------|-----------|------------------|----------------|
| Item ID: Revision ID: Item Name: | D2221 350 Basket E | 3ase | | Accept | *N900 | 040 | 100 |)* | Setup Sta | ı A | S1* S2* |
| Start Date: Required Date: Reference: | 3/4/2013 4/9/2013 | Start Qty: 1.00 Req'd Qty: 1.00 | *1* *1* | | Cust Item II Customer: | D: | | | | | |
| Approvals: | | lan: | Date: | Tooling: SPC (Y/N): | | te: | | | Run Sta | " \ | R1* R2* |
| Sequence ID/ Work Center II 150 *150* | D | Operation Description Identify as per dwg & Sto | ock Location: <u>D-35</u> | Set Up/ Run Hours D-6007-041 | Tool ID 48077 | Tool# | Plan Code | Accep Qty | Qty | Reject Number | Insp. Stamp |
| Packaging Packaging | | Мето | | 0.00 | | | | | · · | 7 - 7 - | |
| 160 | | OC21- Final Inspection - | Work Order Release | 0.00 | | | | | | _ / / | 1. |

0.00

Memo

160

Quality Control

W13-03-19

| | | | | | | | | | | | DQA: | Date: | |
|---------------|-------|----------|----------|--------------|-----|----------------------------|-----|----------|---------------------------------------|---------|--------------|---------------|--------------------|
| NCR: | Yes | / No | | | | WORK ORDER NON- | COI | NFORM | MANCE / UPDATE | | | _ | |
| | | | | | | | | | · · · · · · · · · · · · · · · · · · · | | QA Closed: | Date: | |
| Work Ord | or: | | | | | DISPOSITION | | | AGA | INST DE | PARTMENT | PROCESS | |
| WORK Ord | er. | | | = | | Rework | 7 | | Skid-tube Cross | stube | | Water Jet | Engineering |
| Part I | Nο | | | | | Scrap | | |) | Fab | Pro | d. Eng. Coor. | Quality |
| , uici | ••• | | | | | Use-as-is | 1 | 1 | ~ | shing | | re/Packaging | Other |
| NCR I | No. | | | | | Work Order Update | 1 | | Large Fab Comp | | · | Supplier | |
| | | | | · | | | | | | | | | |
| Root | | | | | l | ption of work order update | 1 | Initial | Action | | Sign & | | } |
| Cause | , | Date | Step | Qty | | or Non-conformance | Ch | nief Eng | Description | | Date | Verification | QC Inspector |
| Doc/Data | 匚 | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | |
| Operator | L | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | |
| Setup | | | | | | | 1 | | | | | | |
| Other | L_ | | | | | | | | | | | | |
| Process | | | İ | | : | | | | | | | | |
| Supplier | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | |
| Unapproved | | | <u> </u> | | | | | | | | <u> </u> | | |
| | | | | | | F | AUI | LT CATE | GORY | | | | |
| Landi | ing (| Gear | | | | General | | _ | | | - | | |
| | | Bending | | | | Bend | L | Grain | | | Ovalized | <u></u> | Pressure/Forced |
| | | Centre N | ot Conce | ntric to | o/s | BOM/Route | L | Hardwa | re | | Over/Under | tolerance | Temperature/Cure |
| | | Cracks | | | | Broken/Damaged | | inspect | ion Incomplete | | Part Incorre | ct | Weld |
| | | Crushed/ | Crimped | | | Burrs | | Instruct | ions Incomplete/Unclear | | Part Lost/M | issing | Wrong Stock Pulled |
| | | Cuffs | | | | Contamination | | Mainte | enance | | Part Moved | | |

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

Tuesday, March 05, 2013 1:35:39 PM

Work Order ID: 98028

98028

Parent Item:

D2221

Parent Item Name:

350 Basket Base

Start Date: 3/4/2013

Required Date: 4/9/2013

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM

IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC

plug holes prior to powder coat DD verified by:EC IPP Rev:L 08-09-24 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N

10.06.29 added pressure wash DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|--------------------|----------------|---------------|
| D2221-1 | | Manufactured | No | | | 100 | Each | 12.0000 | 1 | 1 | 0 | | |
| *D221-1* | | | | | | | | | ** | 7 61 | CpCx | 3.3. | 2 |
| 740 | | | | Location | | Loc | Qty | Loc Code | | 506 | 848- | (| D |
| | | | | WA005 | | | 12 | | | | | | |
| | | | | | 86847 | | 1 | | | | _ | | |
| | | | | | 86848 | | 1 | | _ | | _ | | |
| | | | | | 90856 | | 10 | | _ | | | | |
| D2221-5 | | Manufactured | No | | | 100 | Each | 7.0000 | 2 | 2 | 1 | | |
| *D2221-5 *D2221-5* | | | | | | | | | ** | 7 | (pl) 70840 | 3.3.16 | 3 |
| | | | | Location | | Loc | Oty | Loc Code | | 7 | 10010 | | رع |
| | | | | WA004 | | | 5 | | | | | | |
| | | | | | 90840 | | 5 | | | | _ | | |
| | | | | WA006 | | | 2 | | | | _ | | |
| | | | | | 67117 | | 2 | | | | | | • |
| D2221-7 | | Manufactured | No | | | 100 | Each | 5.0000 | 1 | 1 | | 2 | |
| *D221-7* | | | | | | | | | ** | | <i>Ep</i> B 893 | (13. | 3./2 |
| | | | | Location | | Loc | Oty | Loc Code | | | 5 875 | 578- | (|
| | | | | WA004 | | , | 5 | | | | | | |
| | | | | | 89398 | | 5 | | _ | | _ | • | |

| | | | | | | | | | | | DQA: | Date: | |
|---------------------------------------|-------|-----------|----------|----------|-----|----------------------------|-----|----------|------------|------------|------------|---------------------------------------|------------------|
| NCR: | Yes | / No | | | | WORK ORDER NON-C | O | VFOR | MANCE / UP | DATE | | - | |
| · · · · · · · · · · · · · · · · · · · | | | | | | · | | | | | QA Closed: | Date: | |
| Work Orde | er. | | | | | DISPOSITION | | | | AGAINST DE | PARTMENT | /PROCESS | |
| Work Orde | _ | | | | | Rework | | | Skid-tube | Crosstube | | Water Jet | Engineering |
| Part N | No. | | | | | Scrap | | 1 | Machining | Small Fab | Pro | d. Eng. Coor. | Quality |
| | | | | | | Use-as-is | | Thern | noforming | Finishing | Rec/Sto | re/Packaging | Other |
| NCR N | No | | | | | Work Order Update | } | | Large Fab | Composite | | Supplier | |
| | | | | | | | _ | <u> </u> | | | _ | · · · · · · · · · · · · · · · · · · · | |
| Root | | | | | | ption of work order update | 1 | Initial | | tion | Sign & | | |
| Cause | | Date | Step | Qty | | or Non-conformance | Ct | nief Eng | Desc | ription | Date | Verification | QC Inspector |
| Doc/Data | Ш | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | • | | | |
| Operator | | | ĺ | | | | | | | | | | |
| Material | Ш | | , | | | | ١ | | | | | | |
| Setup | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | |
| Process | Ш | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | |
| Training | | | ļ | | | | | | - | | | | : |
| Unapproved | | | | | | | | | | | | . | · |
| | | | | | | F | AUI | LT CATE | GORY | | | | |
| Landi | ing G | ear | ` | | | General | | _ | | | _ | ********* | , - |
| | | Bending | | | | Bend | | Grain | | <u></u> | Ovalized | <u> </u> | Pressure/Forced |
| 1 | | Centre No | ot Conce | ntric to | o/s | BOM/Route | | Hardwa | ire | | Over/Under | tolerance | Temperature/Cure |

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish Folio

Burrs

Weld

Other

Wrong Stock Pulled

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Tuesday, March 05, 2013 1:35:39 PM

Work Order ID: 98028

98028

Parent Item:

D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 3/4/2013

Required Date: 4/9/2013

Start Qty: 1.00

Required Qty: 1.00

D2232-3

Manufactured No 100

Each 16.0000

2

**

Basket Hinge

Location Loc Oty Loc Code WA004 16

Each

Each

26

75581 2 89358 14 100

Manufactured No

Manufactured

No

13.0000 **

Basket Rib

D2581

D2235-1

Location Loc Oty Loc Code WA004 13

66895 85602 86051 88209 100

48.0000

**

D2581 Mounting Bracket

| <u>Location</u> | Loc Qty | Loc Code |
|-----------------|---------|----------|
| WA004 | 48 | |
| 70766 | 2 | |
| 81253 | 1 | |
| 82506 | 2 | |
| 83230 | 3 | |
| 85452 | 2 | |
| 87706 | 2 | |
| 92871 | 10 | |

94204

| NCR: Yes | s / No | | | | WORK ORDER NON-O | O | NFORI | MANCE / UP | DATE | QA Closed: | Date: | |
|---|---------|-------------|----------|--------|---|-----|-----------------|--|---|------------------------|--|----------------------------------|
| Mark Orden | | | | | DISPOSITION | | | | AGAINST DE | | | region |
| Work Order: Part No NCR No | | | | | Rework Scrap Use-as-is Work Order Update | | 1 | Skid-tube Machining noforming Large Fab | Crosstube Small Fab Finishing Composite | 4 | Water Jet d. Eng. Coor. e/Packaging Supplier | Engineering Quality Other |
| Root | ja . | | | Descri | ption of work order update | 1 | nitial | Ac | tion | Sign & | · - | |
| Cause | Date | Step | Qty | (| or Non-conformance | Ch | ief Eng | Desc | ription | Date | Verification | QC Inspector |
| Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved | | | | | | | | | | | | |
| | | | | | | AUL | T CATE | GORY | | | | |
| Landing | Bending | ot Conce | ntric to | o/s | General Bend BOM/Route | | Grain Hardwa | ıre | | Ovalized Over/Under | tolerance | Pressure/Forced Temperature/Cure |

Inspection Incomplete

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

Burrs

DQA:

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Date:

Weld

Other

Wrong Stock Pulled

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

6

90866

95286

| | | | | | | | | | | | | DQA: | Date | 2:_ | | |
|---------------|------|------------|------------|------------|--------|----------------------------|----------|-----------|------------------------|-----------|-----------------------|---------------|--------------|-------------|--------------------|--|
| NCR: | Yes | / No | | | | WORK ORDER NON- | COI | NFORM | /IANCE / UPI | DATE | | - | | _ | | |
| | | | | | | ····· | | | | ··· | (| QA Closed: | Date | 9: | | |
| Work Orde | or: | | | | | DISPOSITION | | | | AGAINST D | ST DEPARTMENT/PROCESS | | | | | |
| WOIK Olde | - | | | | | Rework | ٦ | , | Skid-tube | 7 | Water Jet | | | Engineering | | |
| Part N | No. | | | | | Scrap | | Machining | Crosstube Small Fab | 1 | Prod. Eng. Coor. | | | Quality | | |
| | - | | | | | Use-as-is | Therm | noforming | Finishing | | Rec/Stor | e/Packaging | | Other | | |
| NCR N | No. | | | | | Work Order Update | | | Large Fab | | | | | | | |
| Root | | | Ţ | | Descri | ption of work order update | П | Initial | Act | tion | T | Sign & | | Т | | |
| Cause | | Date | Step | Qty | (| or Non-conformance | Ch | nief Eng | Desci | ription | | Date | Verification | | QC Inspector | |
| Doc/Data | Ш | | | | | | | | | | | | | | | |
| Equip/Tooling | Ш | | | | | | | | | | Ì | | | | | |
| Operator | Ш | | | | | | | | | | | | | ı | | |
| Material | Ш | | 1 | | | | | | | | | | | | | |
| Setup | Ш | | ļ | | | | | | | | ļ | | | | | |
| Other | Ш | | | | | | | | | | | | | | | |
| Process | Ш | | | | | | | | | | | | | 1 | | |
| Supplier | Ц | | | | | | | | | | 1 | | | İ | | |
| Training | Ш | | | | | | | | | | ļ | | | | | |
| Unapproved | | | <u> </u> | | | | | | | | | | | | | |
| | | | | | | <u> </u> | AUI | LT CATE | GORY | | | | | | | |
| Landi | ng G | ear | | | | General | _ | 7 | | _ | | | _ | | | |
| } | Ш | Bending | | | | Bend | <u> </u> | Grain | | <u> </u> | - | Ovalized | Ļ | _ | Pressure/Forced | |
| | Ш | Centre N | ot Concei | ntric to (| o/s | BOM/Route | | Hardwa | re | L | | Over/Under | tolerance | - | Temperature/Cure | |
| | | Cracks | | | | Broken/Damaged | \perp | Inspecti | on Incomplete | <u> </u> | 4 | Part Incorred | ct | | Weld | |
| | Ш | Crushed/ | Crimped. | | | Burrs | | -{ | ions Incomplete/ | Unclear | _ | Part Lost/Mi | ssing | | Wrong Stock Pulled | |
| | Ш | Cuffs | | | | Contamination | | Mainte | | L | | Part Moved | | | | |
| | Ш | Heat Trea | at | | | Countersink | | Mislabe | led | L | _ | Positioned V | | | | |
| | | Inspectio | n Strip in | Tube | | Cut Too Short | | Misread | i | | | Power Loss/ | Surge | | Other | |
| | | Ripples in | n Bend | | | Drill Holes | | Offset | | | | | | | | |

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Loc Qty

14

Loc Code

Location

WA007

Mesh (Base End Face)

| NCR: | Yes | / No | | | | WORK ORDER NON-C | O | NFORM | ANCE / UPD | DATE | • | | |
|---------------|------------|------------|-------------|----------|----------|----------------------------|----------|---------|-------------------|-------------|--------------|---------------|--------------------|
| | | | | | | | | | | | QA Closed: | Date: | |
| Work Orde | or. | | | | | DISPOSITION | | | | AGAINST DE | PARTMENT | PROCESS | |
| WOIK OIG | - | | | | | Rework |] | | Skid-tube | Crosstube | | Water Jet | Engineering |
| Part i | No. | | | | | Scrap | | | Machining | Small Fab | Pro | d. Eng. Coor. | Quality |
| | | | | | | Use-as-is |] | Therm | noforming | Finishing | Rec/Stor | e/Packaging | Other |
| NCR I | No. | | | | | Work Order Update |] | | Large Fab | Composite | } | Supplier | |
| Root | | | | | Descri | ption of work order update | | Initial | Act | ion | Sign & | : | |
| Cause | | Date | Step | Qty | (| or Non-conformance | Ch | ief Eng | Descr | iption | Date | Verification | QC Inspector |
| Doc/Data | Ш | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | ļ | | | | | • | |
| Operator | | | | | | | | | | | | | İ |
| Material | Ш | | | | | | ļ | | | | | | |
| Setup | Ц | | | | | | | | | | | | |
| Other | Ш | | | | | | | | | | | | |
| Process | Ш | | | | | | 1 | | | | | | |
| Supplier | Ш | | | | | | | | | | | | |
| Training | Ш | i | Į | | | | | | | | | | |
| Unapproved | | | <u> </u> | <u> </u> | <u> </u> | *** | <u> </u> | | | | <u> </u> | | |
| | | | | | | | AUI | LT CATE | GORY | | | | |
| Landi | | 1 | | | | General | _ | 7 | | | 7 | _ | - |
| | lacksquare | Bending | | | ļ | Bend | | Grain | | _ | Ovalized | _ | Pressure/Forced |
| | L | Centre N | ot Conce | ntric to | o/s | BOM/Route | | Hardwa | | | Over/Under | ⊢ | Temperature/Cure |
| | | Cracks | | | | Broken/Damaged | | - | ion Incomplete | _ | Part Incorre | | Weld |
| | \vdash | Crushed/ | Crimped | | | Burrs | | 4 | ions Incomplete/U | Jnclear | Part Lost/M | issing | Wrong Stock Pulled |
| | | Cuffs | | | <u> </u> | Contamination | L | Mainte | enance | | Part Moved | | |
| | | Heat Trea | at | | | Countersink | | Mislabe | eled | L | Positioned \ | Wrong | |
| | | Inspectio | n Strip in | Tube | | Cut Too Short | | Misread | t | | Power Loss/ | 'Surge | Other |
| | | Ripples ir | n Bend | | | Drill Holes | | Offset | | | | | |

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

ITEM QTY х 2 1 5 2 6 2 2 8 2 9 2 10 2 11 12 2 13 98028 N13-03-5 **D2221 BASKET BASE ASSEMBLY (AS350)** (MESH SHOWN LOCALLY FOR CLARITY) NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT: 42.00 lbs APPROX
9) MASK ALL HOLES PRIOR TO POWDER COATING 08.09.18

DESCRIPTION P/N D2221 BASKET BASE ASSEMBLY (AS350) D2221-1 RIB D2221-5 RIB D2221-7 RIB D2232-3 BASKET HINGE D2235-1 RIB D2581 MOUNTING BRACKET D3442-1 SHIM D3825-041 RIB ASSY (BASKET END) RIB/GUSSET ASSY D3826-041 D3827-041 RIB ASSY (INBOARD) D3833-1 MESH, BASE END FACE D3832-1 MESH (BASE)

| Ĥ | REVISED PARTS LIST AND ADDED TITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A.A. BA AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED DETAIL E (ZN B6-4); ADDED DWG DETAILS FOR D2221-11-5-7. (ZN B2-4); ADDED DWG DETAILS FOR D2221-11-5-7. (ZN B2-4); TOL REVISED TO 2 DEC PLACES (ZN B8-3 AND ZN B4-3); D3625-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2225-7-041 REPLACES D2231-1-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1 REASON: SATISFY "LEAN MANUFACTURING" PROGRAM. | мв | 08.09.18 |
|------|--|-----|----------|
| G | MATERIAL FOR -135. 87 WAS 0.050 WALL: TOLERANCE FOR 96.00 DIM WAS. +0.01 AND 66.00 DIM WAS REF (ZN 85-2), 19.62 DIM WAS. +1ARD' DIMENSION IS. NOW "REF" (ZN 84-2); NOTE 5 TRANSFERED FROM SHI 1 TO SHI 2: SHI 2 MESH MATERIAL UPDATED; DRAWING TRANSFERED TO "B" FORMAT | AJS | 08.06.16 |
| F | ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET | РН | 05.06.07 |
| ε | CHANGE HINGE | CP | 01.04.19 |
| D | CHANGE LATCH | 8W | 96.06.21 |
| С | SEPARATE BASKET AND LID | KH | 95.11.21 |
| REV. | DESCRIPTION | BY | DATE |

| REV. | | DESCRIPTION | BY | DAIL |
|------------|---------|---------------|----------------|--------------|
| DESIGN | ВW | DART AER | OSPACE L | TD |
| DRAWN | | | ONTARIO, CANAL | |
| CHECKED | IVSS | DRAWING NO. | | REV. H |
| MFG. APPR. | Ma | D2221 | | SHEET 1 OF 5 |
| APPROVED | Mes | TITLE | | SCALE |
| DE APPR. | -#- | BASKET BASE A | SSEMBLY (| (350) мтѕ |
| | | | | |

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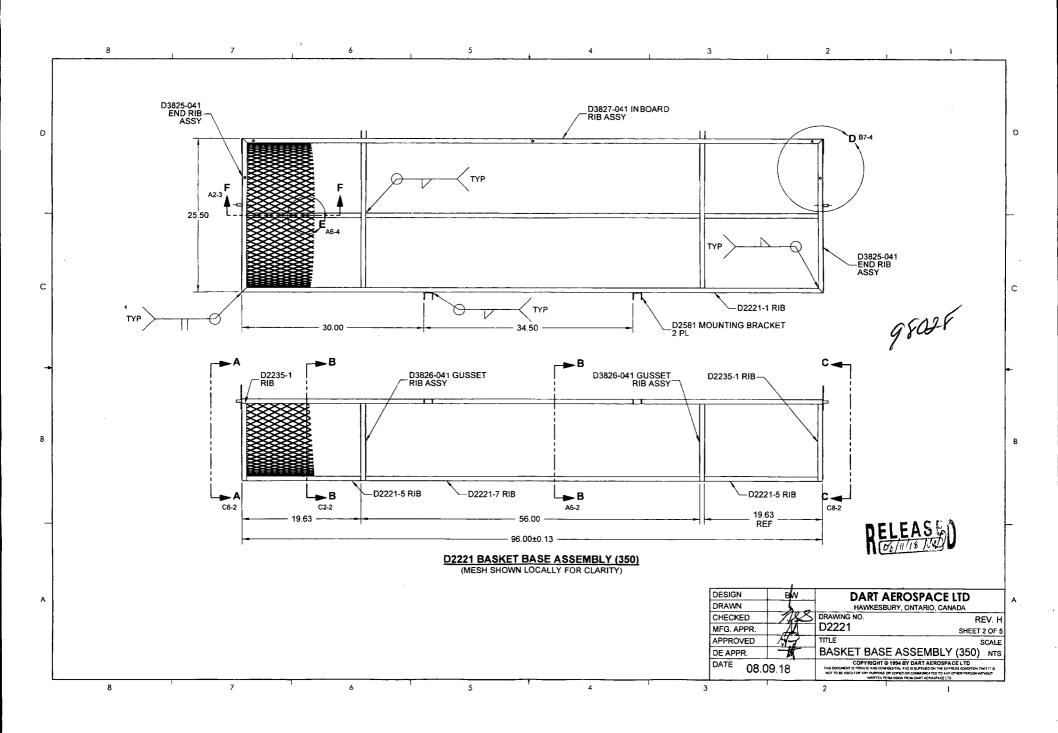
| | | | | | | | | | | | DQA: | Date: . | |
|---------------|---------|------|------|-----|---------------------------------------|--------------------------------|----------|------------|----------------------|---------------------|------------|-----------------------|--------------|
| NCR: Y | 'es | / No | | | | WORK ORDER NON-C | ON | NFORM | MANCE / UP | DATE | QA Closed: | Date: | |
| Work Orde | er: | | | | | DISPOSITION | | AGAINST DE | T DEPARTMENT/PROCESS | | | | |
| | _ | | | | · · · · · · · · · · · · · · · · · · · | Rework | | | Skid-tube | Crosstube | | Water Jet | Engineering |
| Part N | ۱o. | | | | | Scrap | | I | Machining | Small Fab | Pro | d. Eng. Coor. | Quality |
| NCR N | - No | | | | | Use-as-is Work Order Update | | Thern | noforming Large Fab | Finishing Composite | Rec/Sto | re/Packaging Supplier | Other |
| Root | | | | | Descri | ption of work order update | 1. | nitial | Ac | tion | Sign & | | |
| Cause | | Date | Step | Qty | , | or Non-conformance | Ch | ief Eng | Desc | ription | Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | |
| Setup | | | ! | | | | 1 | | | | | | |
| Other | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | |

| Landing | Gear | General | | | | - |
|---------|------------------------------|----------------|---------------------------------|----------------------|------------|-----------|
| | Bending | Bend | Grain | Ovalized | Pressure/F | orced |
| Γ | Centre Not Concentric to O/S | BOM/Route | Hardware | Over/Under tolerance | Temperatu | re/Cure |
| | Cracks | Broken/Damaged | Inspection Incomplete | Part Incorrect | Weld | |
| | Crushed/Crimped. | Burrs | Instructions Incomplete/Unclear | Part Lost/Missing | Wrong Sto | ck Pulled |
| | Cuffs | Contamination | Maintenance | Part Moved | | |
| | Heat Treat | Countersink | Mislabeled | Positioned Wrong | | |
| | Inspection Strip in Tube | Cut Too Short | Misread | Power Loss/Surge | Other | |
| | Ripples in Bend | Drill Holes | Offset | | | |
| | Torque Waves in Extrusion | Drawing | Out of Calibration | | | |
| | Turning Sequence | Finish | Out of Sequence | | | |
| | Wave/Twist in Tube | Folio | Outside Dimensions | | | |

FAULT CATEGORY

Supplier Training Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



| | | | | | | | | | | | DQA: | Date: | · |
|---------------|--------|---------|----------|----------|-------------|----------------------------|----------|---------|----------------------|-------------|--------------|---------------|--------------------|
| NCR: | Yes / | No | | | | WORK ORDER NON-C | O | NFORM | AANCE / UPDAT | | | | |
| _ | | | | | | | | | | | QA Closed: | Date: | |
| Morle Orde | a.r. | | | | : | DISPOSITION | | | , | AGAINST DEF | PARTMENT | PROCESS | |
| Work Orde | er: | | | | | Rework | 1 | | Skid-tube C | rosstube | | Water Jet | Engineering |
| Part f | No. | | | | | Scrap | | | —— | Small Fab | Pro | d. Eng. Coor. | Quality |
| | | | | | | Use-as-is | 1 | Therm | noforming | Finishing | Rec/Stor | e/Packaging | Other |
| NCR I | No | | | | | Work Order Update | | | Large Fab Co | omposite 🔃 | | Supplier | |
| | | | | | T | | | | | , | 6: 0 | | |
| Root | | | _ | | | ption of work order update | i | nitial | Action | | Sign & | V (6) | 061 |
| Cause | | ate | Step | Qty | • | or Non-conformance | Ch | ief Eng | Description | on | Date | Verification | QC Inspector |
| Doc/Data | Ш | | | | | | | | | | | | |
| Equip/Tooling | Ш | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | |
| Material | Ш | | | | | | | | | | | | |
| Setup | Ш | | | | ļ | | | | | | | | |
| Other | Ш | | | | | | | | | | | | |
| Process | Ш | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | |
| Training | Ш | | | | | | | | | · | | | |
| Unapproved | | | | | | | | | | | | | 1 |
| | | | | | | | AUL | T CATE | GORY | | <u></u> | | |
| Landi | ng Gea | | | | - | General | | 7 | | | l | <u> </u> | ٦ |
| | Bei | nding | | | | Bend | <u>_</u> | Grain | | | Ovalized | <u> </u> | Pressure/Forced |
| | Cei | ntre No | t Concer | ntric to | O/S | BOM/Route | | Hardwa | ire | | Over/Under | | Temperature/Cure |
| | Cra | cks | | | | Broken/Damaged | | -l ` | ion Incomplete | | Part Incorre | | Weld |
| | Cru | shed/ | Crimped. | | | Burrs | | -i | ions Incomplete/Uncl | ear | Part Lost/M | _ | Wrong Stock Pulled |
| | Cu | fs | | | | Contamination | | Mainte | enance | | Part Moved | | |
| | He | at Trea | t | | | Countersink | | Mislabe | eled | | Positioned \ | V rong | |

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence
Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

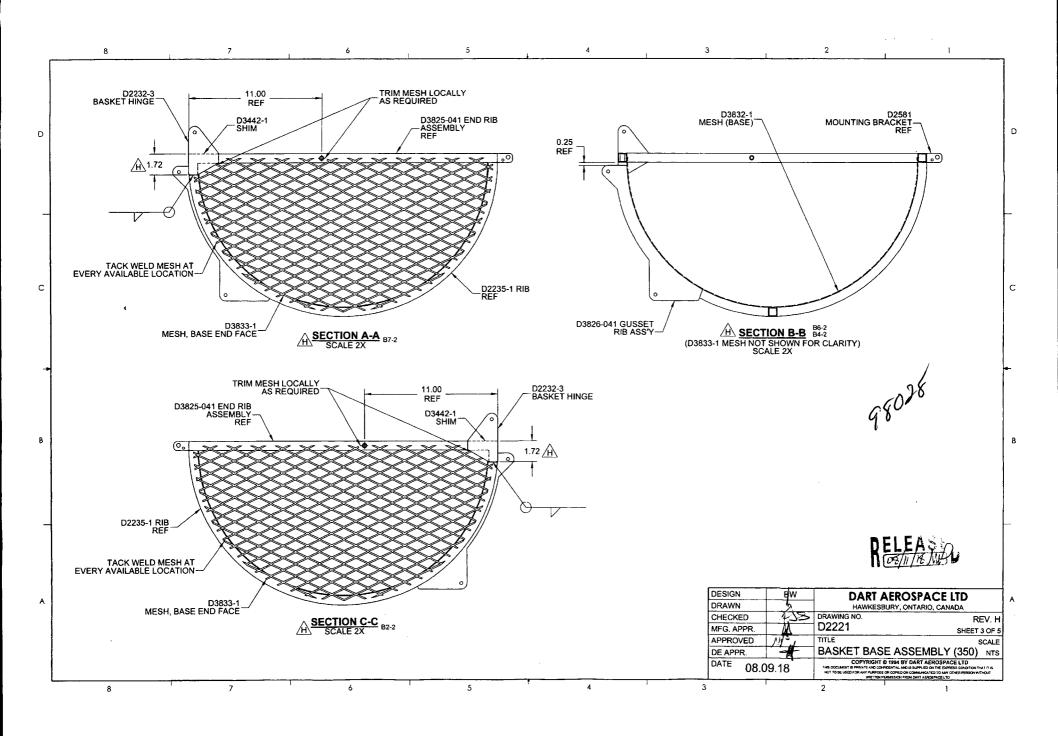
Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



| | | | | | | | | | | | | DQA: | Dat | e: | |
|------------------|----------|-----------|------------|----------|-------------|----------------------------|----------|-------------------------|------------------------|---------------------|------------------|--------------|---------------|----------|--------------------|
| NCR: | Yes | / No | | | | WORK ORDER NON-O | CON | NFORN | ANCE / UP | DATE | | _ | | | |
| | | | | | | | | | | | Q | A Closed: | Dat | ie: | |
| | | | | | | DISPOSITION | | AGAINST DEPARTMENT/PROC | | | | | | | |
| Work Ord | er: - | | | | | Rework | , | | | | 7 | Water Jet | | | Engineering |
| Part I | No. | | | | | Scrap | | | Skid-tube Machining | Crosstube Small Fab | + | Proc | d. Eng. Coor. | \dashv | Quality |
| raiti | ٠ | | · | | | Use-as-is | 1 1 | | noforming | Finishing | 1 | | e/Packaging | \dashv | Other |
| NCR I | No. | | | | | Work Order Update | 1 | | Large Fab | Composite | 1 | 1100,000 | Supplier | | |
| | - | | | | | | - | | | · L | <u> </u> | _ | | | |
| Root | | | | | Descri | ption of work order update | 1 | nitial | Ac | tion | T | Sign & | | | |
| Cause | | Date | Step | Qty | (| or Non-conformance | Ch | ief Eng | Desc | ription | | Date | Verification | n | QC Inspector |
| Doc/Data | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | i | | | İ | | | | |
| Operator | | | | | | | | | | | | | | | |
| Material | Ш | | | | | | | | | | | | | 1 | |
| Setup | Ш | | | | | | | | | | | | | | |
| Other | Ш | | | | | | | | | | | | | ļ | |
| Process | Ш | | | | | | | | | | | | | 1 | |
| Supplier | Ш | | | | | | | | | | | | | | |
| Training | Ш | | İ | | | | | | 1 | | | | | 1 | |
| Unapproved | | | <u> </u> | | | | <u> </u> | | | | | | | | |
| | | | - | | · | | AUL | T CATE | GORY | | | | | | |
| Landi | <u> </u> | i | | | _ | General | _ | 1 | | | ٦. | | | _ | 1_ /_ / |
| | \vdash | Bending | | | | Bend | \vdash | Grain | | - | _ | Ovalized | | <u> </u> | Pressure/Forced |
| | - | Centre N | ot Concei | ntric to | o/s | BOM/Route | <u> </u> | Hardwa | | | - | Over/Under | | \vdash | Temperature/Cure |
| | \vdash | Cracks | | | <u> </u> | Broken/Damaged | \vdash | 4 | ion Incomplete | | | art Incorred | | <u> </u> | Weld |
| Crushed/Crimped. | | | | | <u> </u> | Burrs | <u> </u> | 4 | tions Incomplete/ | /Unclear | ┥. | art Lost/Mi | ssing | <u></u> | Wrong Stock Pulled |
| Cuffs | | | | | L | Contamination | | Mainte | | | Part Moved | | | | |
| Heat Treat | | | | | <u> </u> | Countersink | _ | Mislabe | | <u> </u> | Positioned Wrong | | | _ | 7 |
| | 1 1 | Inspectio | n Strip in | Tube | 1 | Cut Too Short | 1 | Misread | <u>t</u> | | l F | ower Loss/ | Surge | 1 | Other |

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

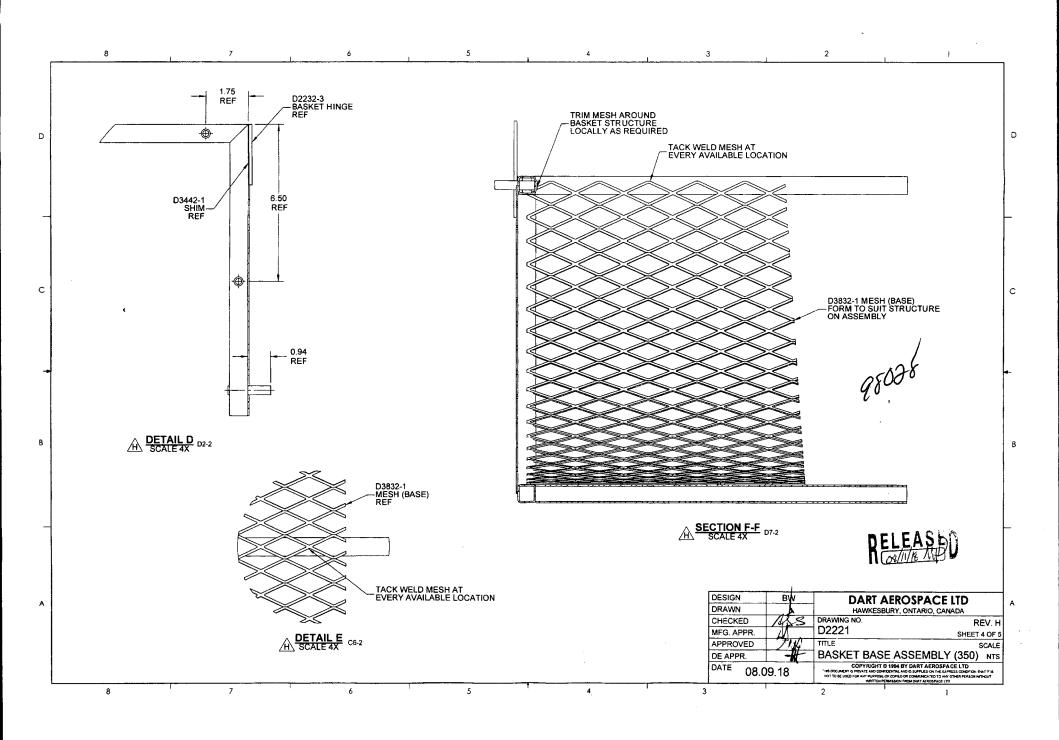
Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio



| | | | | | | | | | | | DQA: | Date | 2: | |
|---------------|----------|-----------|------------|----------|-------------|----------------------------|---------|---------------------|----------------------------|---------------|--------------|-----------------|--------------------|--|
| NCR: | es/ | / No | | | | WORK ORDER NON-O | O | NFORM | ANCE / UPDAT | ΓΕ | , | ·· · | | |
| | | , | | | | | | | · | | QA Closed: | . Date | j: | |
| NA(nuli Oud | | | | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
| Work Orde | er. • | | | | | Rework | 1 | Skid-tube Crosstube | | | | Water Jet | Engineering | |
| Part I | No. | | | | | Scrap | 1 | | | Small Fab | Pro | d. Eng. Coor. | Quality | |
| | | | | | | Use-as-is | | Therm | noforming | Finishing | Rec/Sto | e/Packaging | Other | |
| NCR I | No. | | | | | Work Order Update |] | | Large Fab Co | omposite | | Supplier | | |
| | | | | | | | | | | | | | | |
| Root | | | | | | ption of work order update | 1 | Initial | Action | | Sign & | | | |
| Cause | | Date | Step | Qty | (| or Non-conformance | Ch | ief Eng | Description | on | Date | Verification | QC Inspector | |
| Doc/Data | | | | | | | 1 | | | | | | | |
| Equip/Tooling | Ш | | | | | | | | | | | | | |
| Operator | Щ | | | | | | 1 | | | | | | | |
| Material | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | } \$ | | | |
| Other | | | | | | | | | | | | | | |
| Process | Ш | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | |
| Unapproved | | | <u>.</u> | | | | | | | | | | | |
| | | | | | | | AUL | T CATE | GORY | | | | | |
| Landi | ng (| Gear | | | | General | _ | ٦ | | r | ٦ | r | \neg | |
| | | Bending | | | <u></u> | Bend | _ | Grain | | _ | Ovalized | - | Pressure/Forced | |
| | <u> </u> | Centre No | ot Concer | ntric to | o/s | BOM/Route | <u></u> | Hardwa | | _ | Over/Under | | Temperature/Cure | |
| | | Cracks | | | | Broken/Damaged | | 4 | ion Incomplete | | Part Incorre | ⊢ | Weld | |
| | | Crushed/ | Crimped. | | | Burrs | | Instruct | ions Incomplete/Uncl | ear | Part Lost/M | _ | Wrong Stock Pulled | |
| Cuffs | | | | | <u> </u> | Contamination | | Mainte | enance | | Part Moved | | | |
| Heat Treat | | | | | | Countersink | | Mislabe | eled | | Positioned \ | Wrong _ | | |
| | | Inspectio | n Strip in | Tube | | Cut Too Short | Misread | | | | Power Loss, | 'Surge | Other | |

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

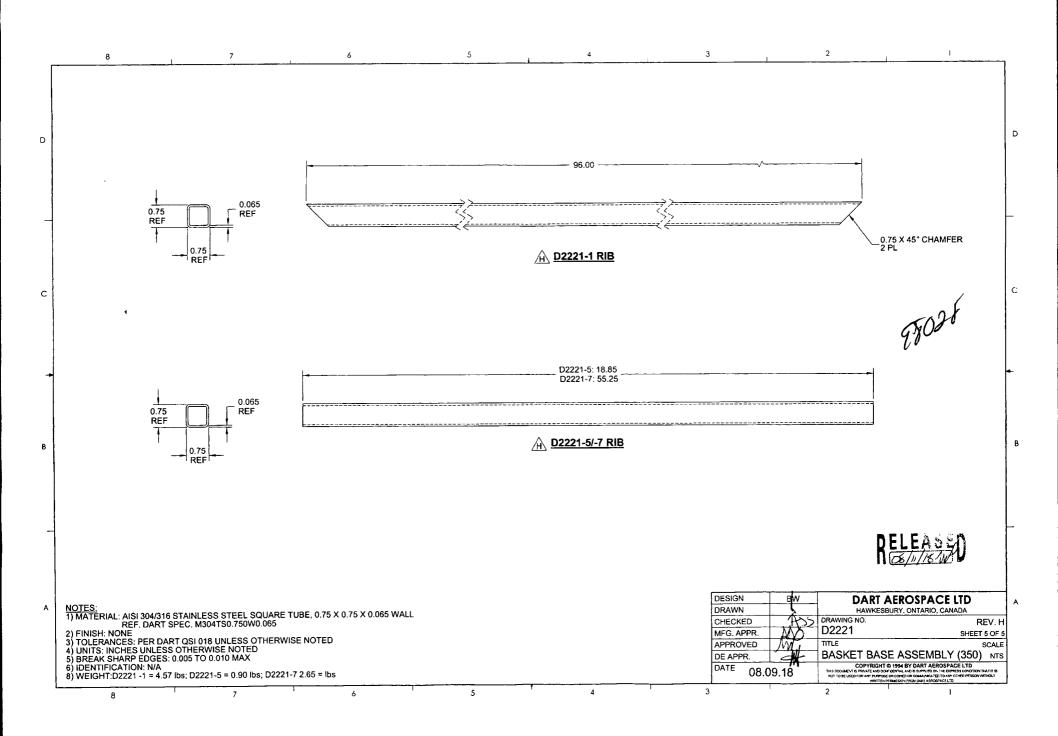
Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



| | | DQA: | Date: | |
|---------------|-------------------------------------|------|-------|--|
| ICR: Yes / No | WORK ORDER NON-CONFORMANCE / UPDATE | | | |

| | | | | | | | | | | | QA Closed: | Dat | te: | | |
|-------------------------------|-------|-------------|----------|----------|-------------|----------------------------|-------------------|----------------------------|------------------|---------------------------------------|--------------|---------------|--------------------|--|--|
| Work Orde | er: | | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | | |
| Work or a | - | | | | | Rework | 7 | Skid-tube Crosstube | | | | Water Jet | Engineering | | |
| Part I | No. | | | | | Scrap | 1 I | Machining Small Fab | | | Pro | d. Eng. Coor. | Quality | | |
| 1 4.0. | • | | | | | Use-as-is | † _{TI} | Thermoforming Finishing | | | | re/Packaging | Other | | |
| NCR 1 | No. | | | | | Work Order Update | 1 " | Large Fab Composite | | | | Supplier | | | |
| | - | | | | | · <u> </u> | - | | · | | | | | | |
| Root | | | | | Descri | ption of work order update | Initi | ial | A | ction | Sign & | | | | |
| Cause | | Date | Step | Qty | | or Non-conformance | Chief | Eng | Des | cription | Date | Verification | n QC Inspector | | |
| Doc/Data | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | |
| Operator | | | | | | | 1 | | | | | | | | |
| Material | | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | 1 | | | |
| Other | | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | |
| Supplier | | |] | | | | | | | | | | | | |
| Training | | | 1 | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | <u> </u> | | | |
| | | | | | | F | AULT C | ATE | GORY | · · · · · · · · · · · · · · · · · · · | | | | | |
| Landi | ng G | ear | | | | General | | | | | • | | | | |
| | | Bending | | | | Bend | Gr | ain | | | Ovalized | | Pressure/Forced | | |
| | | Centre N | ot Conce | ntric to | o/s | BOM/Route | На | rdwa | are | | Over/Under | tolerance | Temperature/Cure | | |
| | | Cracks | | | | Broken/Damaged | Ins | spect | ion Incomplete | | Part Incorre | ct | Weld | | |
| | Ш | Crushed/ | Crimped. | | | Burrs | Ins | struct | tions Incomplete | e/Unclear | Part Lost/M | issing | Wrong Stock Pulled | | |
| | Cuffs | | | | | Contamination | M | ainte | enance | | Part Moved | | | | |
| Heat Treat | | | | | | Countersink | Мі | islabe | eled | | Positioned \ | W rong | | | |
| Inspection Strip in Tube | | | | | | Cut Too Short | Мі | isrea | d | | Power Loss, | /Surge | Other | | |
| Ripples in Bend | | | | | | Drill Holes | ∐Of | fset | | | | | | | |
| Torque Waves in Extrusion Dra | | | | | n _ | Drawing | Or | it of | Calibration | | | | | | |
| Turning Sequence Finish | | | | | | Finish | Out of Sequence | | | | | | | | |
| Wave/Twist in Tube | | | | | | Folio | lou | Outside Dimensions | | | | | | | |

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G